

## Jotapipe IL 6001 80S

### PRODUCT DESCRIPTION

This product is a fusion-bonded epoxy coating designed as an anti-corrosion coating for the internal surface of line pipe used to transport non-aggressive media (raw water, sweet and water contaminated oils) up to 110 °C (230 °F).

Jotapipe IL 6001 80S can be applied with or without a primer (Jotapipe PR 460) depending on the specification requirements.

### POWDER PROPERTIES

Property	Standard	Result
<b>Gel time</b>	ISO 8130-6 200 °C	60-100 seconds
<b>Moisture content</b>	CSA-Z245.20 (12.4B)	Below 0.50 % (at time of manufacture)
<b>Particle size</b>	CSA-Z245.20 (12.5)	2.0 % max retained on 150 µm (100 mesh) 0.2 % max retained on 250 µm (60 mesh)
<b>Density</b>	CSA-Z245.20 (12.6)	1520 ± 50 g/l
<b>Thermal characteristics</b>	CSA-Z245.20 (12.7)* Inflection point	T <sub>g1</sub> = 54-70 °C (129-158 °F) T <sub>g2</sub> = 105-115 °C (221-239 °F) ΔH = 40-70 J/g

\* Powder DSC heating cycles, 20 °C/min: 30-70 °C, 30-300 °C under inert gas, (T<sub>g1</sub> and ΔH), 30-140 °C (T<sub>g2</sub>). Cured film DSC heating cycles, 20 °C/min: 30-120 °C and hold 1.5 min, 30-285 °C (T<sub>g3</sub>), 30-140 °C (T<sub>g4</sub>).

These are typical results and should not be viewed as a product specification.

### Storage

When stored at a maximum 25 °C (77 °F), a shelf life of 12 months is obtained from the date of manufacture.

### APPLICATION

#### Powder application

Surface preparation meeting Sa 2½ to Sa 3 with a surface profile of 40-100 µm is recommended.

For details of primer application, refer to TDS of Jotapipe PR 460.

Pre-heat time depends on factors such as plant configuration and pipe characteristics.

Application conditions	Typical application temperature	Typical film thickness
<b>With Jotapipe PR 460 primer</b>	Typical pre-heat temperature 160-180 °C (320-356 °F) Typical post curing temperature and duration 200-220 °C (392-428 °F), 30 minutes	350-625 µm (14-25 mils)

<b>Without primer</b>	Typical pre-heat temperature 200-230 °C (392-446 °F) Typical post curing temperature and duration 200-230 °C (392-446 °F), 30 minutes	350-625 µm (14-25 mils)
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Optimum duration of post cure for different wall thicknesses shall be determined by the applicator and full cure shall be confirmed by a DSC cure test.

Please refer to the relevant Application Guide for guidelines on the factory application of this product.

## PERFORMANCE

Property	Standard	Result
<b>Flexibility</b>	CSA-Z245.20 (12.11) 3.0° PPD at 0 °C (32 °F)	Pass / No cracking
<b>Adhesion</b>	CSA-Z245.20 (12.14) without primer 28 days, 50 °C (122 °F) 28 days, 75 °C (167 °F)	Rating 1 Rating 1
<b>Appearance</b>	AWWA C-213 (5.3.2.4)	Smooth, glossy finish
<b>Impact resistance</b>	AWWA C-213 (5.3.2.5)	> 11.3 J
<b>Abrasion resistance</b>	AWWA C 213 (5.3.2.9) CS-17 wheel, 1 kg load, 5000 cycles	165 mg weight loss
<b>Water soak test</b>	AWWA C 213 (5.3.2.9) 24 hours, 95 °C (203 °F)	Rating 1
<b>Cure test*</b>	CSA-Z245.20 (12.7)	ΔT <sub>g</sub> of ±3 °C is considered as full cure

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## Disclaimer

The information in this document is given to the best of Jotun's knowledge, based on laboratory testing and practical experience. Jotun's products are considered as semi-finished goods and as such, products are often used under conditions beyond Jotun's control. Jotun cannot guarantee anything but the quality of the product itself. Minor product variations may be implemented in order to comply with local requirements. Jotun reserves the right to change the given data without further notice.

Users should always consult Jotun for specific guidance on the general suitability of this product for their needs and specific application practices.

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# Technical Data Sheet

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